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20NR-04
Job Sheet 187727



Part No: 20NR-04

Job Qty: 6 ea

Part Name: Solenoid



Part Weight: 0 lbs

Job Created: 12/12/18

Due Date: 1/4/19

Type: SOLD

Note: DWG 20NR-04 Rev 6 IPP Rev A 18.02.02 New issue DP Verify DD

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/4/19	1/4/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	6 pcs	1/4/19	1/4/19	0.08	0.60	Small Fab-9		Michel
110	QC	6 pcs	1/4/19	1/4/19	0.00	0.00	QC5		
130	Packaging	6 pcs	1/4/19	1/4/19	0.00	0.00	Packaging3-2		
140	QC21-FG	6 Ea	1/4/19	1/4/19	0.00	0.00	QC21		JAN 11 2019

Part Op 100 - 1-Assemble as per DWG sheet 1. 2-Center 20NR-03 in shaft of solenoid as per note 1. ***Note 32446 22-16 crimp
Descriptions: connectors supplied loose as per note 2***
130 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
20NR-04-1	Solenoid	6 Ea (1 ea)	90-Start up Operation	S142326
20NR-04-3	Spacer	6 Ea (1 ea)	90-Start up Operation	S144258
32446	Crimp Terminal	12 Ea (2 ea)	90-Start up Operation	S047075
92383A695	Slotted Spring Pin	6 Ea (1 ea)	90-Start up Operation	S040831

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	20NR-04-1	6	2	0
			35	0
			869	0
			159	0



Container No: S144261



Part: 20NR-04
Job No: 187727
Serial No/Batch: S144261

Revision: 6
Inspector:
Exp Date:
Instructions:

Date: 01/11/19

12/12/18 1:43 PM Dart.lajeunesse.marie

DAS
70
9-89

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

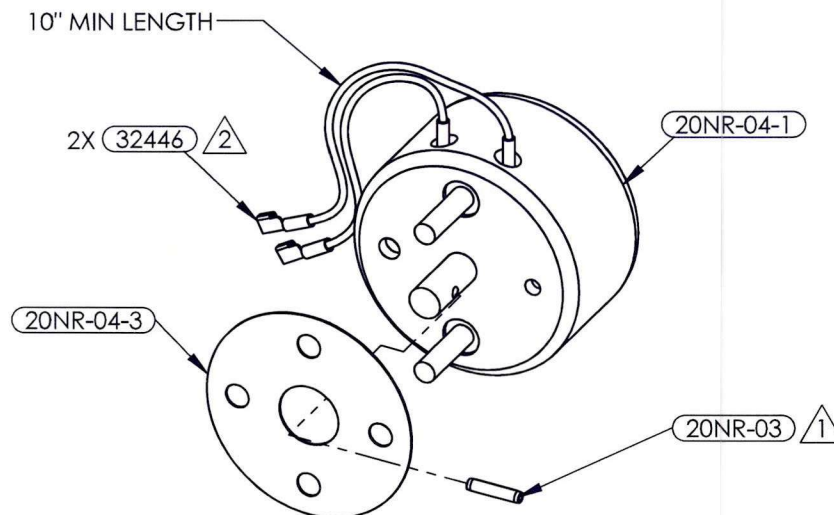
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5		AS DRAWN BY CANAM.	7/18/2013	CFS	
6	14-0206	CH'D TITLEBLOCK WAS RED BARN IS DART. 20NR-04-1 ADDED ENGRAVE BATCH # NOTE. ADDED 20NR-04-3 SPACER, 2X 32446 CONNECTORS. ADDED MIN LENGTH NOTE.	11/3/2014	DPD	JAG



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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 187727 MS
18-12-12

NOTE:

- 1 CENTER 20NR-03 IN SHAFT OF SOLENOID.
2 CONNECTORS SUPPLIED LOOSE.

USED ON
20NR
8NR

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. 20NR-04	REV 6
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 12/1/1998
SHEET 1 OF 3	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	20NR-03	1	SOLENOID PIN	S.S.	Ø1/8 X 5/8 MCMASTER-CARR #92383A695	1
		B/O	20NR-04-1	1	SOLENOID		H-1127-020 (MODIFIED)	2
			20NR-04-3	1	SPACER	PETG	Ø2-5/8 X .020	3
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		ALLIED ELECTRONICS 32446	1